

Work Order ID 57987

April 21, 2010 10:07:36 AM



Page 1

Item ID: D3642-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 21/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3642	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3642 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

2624 .050

B 10-5-10

(14)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-5-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/10

(A/C)

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3642-1 PAR #: _____ Fault Category: Small Parts NCR: Yes No DQA: _____ Date: 10/05/19
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: HJ Date: 10/05/19

NCR: <u>57987</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/05/19</u>	<u>#110</u>	<u>Found on all qty +10 parts that there are a lead in / lead out on the hubs (usually on different hubs) RC.</u>	<u>[Signature]</u>	<u>- Review program: lead in's & cuts. - Review the tip on the machine - scrap all & replace (P112291 - 214)</u>	<u>[Signature] 10-05-19 10-05-19</u>	<u>10-5-19</u>	<u>[Signature]</u>	<u>[Signature] 10/05/19</u>
								<u>[Signature] 10/05/19</u>

NOTE: Date & initial all entries

Work Order ID 57987

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Item ID: D3642-1

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Setup Start



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Start Date: 21/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*el**10/05/10**14**0*

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*14**BR 10-5-10*

150

Identify as per dwg & Stock Location: *55*

0.00



Packaging

Memo

0.00

Packaging

*243**6/10/10**14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 57987

April 21, 2010 10:07:36 AM



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Item ID: D3642-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 21/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/12

MF
10-5-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 10:07:41 AM

Page 1

Work Order ID: 57987



Parent Item: D3642-1



Parent Item Name: Doubler

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	44.9000	1.4013	1.8		



2024-T3 .050 sheet



1810-5-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT22

44.9

111381

32

112291

11

113189

1.9

112291

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	57987
Description: Doubler		Part Number:	D3642-1
Inspection Dwg: D3642	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	.125	✓			
Ø0.098	+0.004/-0.001	.099	✓			
0.35	+/-0.030	.346	✓			
1.25	+/-0.030	1.247	✓			
1.700	+/-0.010	1.700	✓			
2.15	+/-0.030	2.15	✓			
3.05	+/-0.030	3.050	✓			
3.95	+/-0.030	3.952	✓			
4.078	+/-0.010	4.075	✓			
4.85	+/-0.030	4.849	✓			
5.20	+/-0.030	5.192	✓			
0.343	+/-0.010	.347	✓			
0.40	+/-0.030	.407	✓			
1.30	+/-0.030	1.305	✓			
3.35	+/-0.030	3.358	✓			
3.47	+/-0.030	3.475	✓			
3.79	+/-0.030	3.79	✓			
3.959	+/-0.010	3.965	✓			
4.08	+/-0.030	4.100	✓			
4.60	+/-0.030	4.611	✓			
1.537	+/-0.010	1.540	✓			
3.28	+/-0.030	3.285	✓			
3.80	+/-0.030	3.80	✓			
3.915	+/-0.010	3.920	✓			
0.450	+/-0.010	.455	✓			
4.066	+/-0.010	4.066	✓			
4.20	+/-0.030	4.220	✓			

Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	10-5-10	Date:	10/05/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	

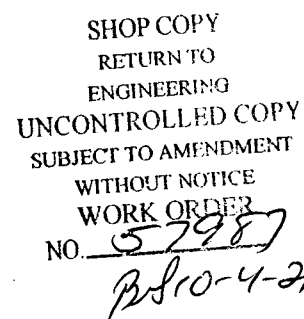
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



RELEASE
9.11.14

NOTES

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. REV. D3642 SHEET 1 OF TITLE SCAL DOUBLER 4 COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE EXPLICIT CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	
DRAWN	UC		
CHECKED	RA		
MFG. APPR.	FC		
APPROVED	JF		
DE APPR.			
DATE	07.10.16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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